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6

D206-667-247TRN
Job Sheet 168213-C



Part No: D206-667-247TRN

Job Qty: 1 ea

Part Name: Crosstube Assembly, Mid Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP rev:A 11.01.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/29/17	0.00	0.00	Start Up Crosstubes		PMP
100	Mori Seiki	1 pcs		11/29/17	3.85	1.33	Mori Seiki TL-40		PMP
110	QC	1 pcs		11/29/17	0.00	0.00	QC2		PMP
120	Mori Seiki	1 pcs		11/29/17	0.00	1.33	Mori Seiki TL-40		PMP
130	QC	1 pcs		11/29/17	0.00	0.00	QC2		PMP
140	QC	1 pcs		11/29/17	0.00	0.00	QC8		47
145	Crosstubes	1 pcs		11/29/17	0.00	0.37	Crosstube		18-098902 8
150	HandFXtube	1 pcs		11/30/17	0.00	0.32	Crosstube		2018/02/09 JSL
160	QC	1 pcs		11/30/17	0.00	0.00	QC7		DPZ
170	Packaging	1 pcs		11/30/17	0.00	0.00	Packaging3		DPZ
180	QC21-SA	1 Ea		11/30/17	0.00	0.00	QC21		21

Part Op 100 - 1-Fill tube with sand & install plugs 206-207 on both ends as per Folio FB030 2-Turn first side as per Folio FB030
Descriptions: 3-Blend transition line with belt sander 60 grit.

120 - 1-Turn second side as per Folio FB030 2-File down transition lines smooth.

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6004-115	1	46	0	0

3116116

Part Specifications

Specifications could not be found.

Plex 11/13/17 12:38 PM dart.poulin.mario

DART
AEROSPACE
S012253

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Crosstube Assembly, Mid Aft

PART NO: D206-667-247TRN

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/21/17

Job No: 168213-C

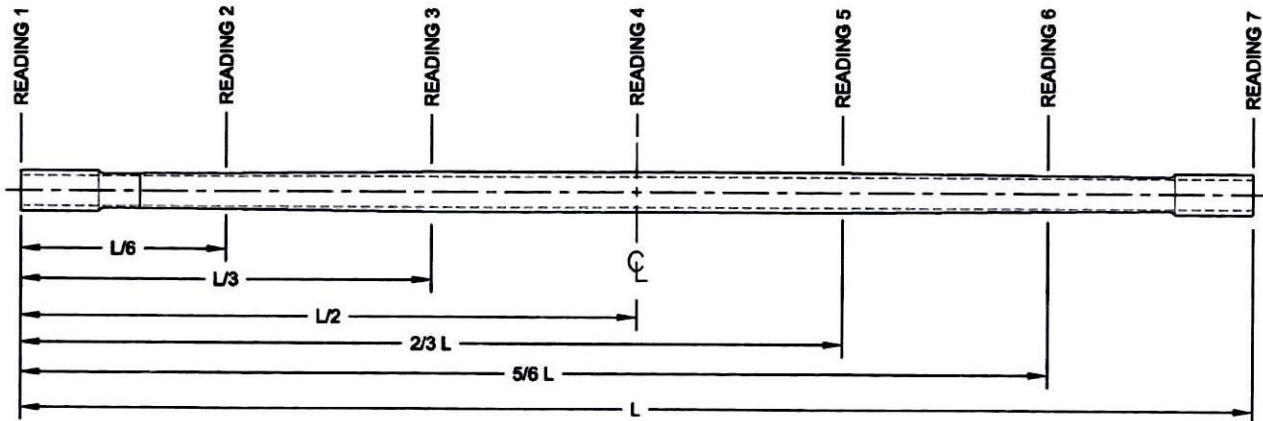
DART AEROSPACE LTD	Work Order:	168213-C
Description: Crosstube Assembly, Mid Aft	Part Number:	D206-667-247
Inspection Dwg: D206-667-247 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.493			VERN 08	
	2.025	+0.005/-0.000	2.0285				
	2.079	+0.005/-0.000	2.0835				
	2.145	+0.005/-0.000	2.150				
	2.209	+0.005/-0.000	2.214				
	2.287	+0.005/-0.000	2.2915				
	2.363	+0.005/-0.000	2.3675				
	0.200	+/-0.010	.200			VERN 08	
	R0.063	+/-0.010	.063			RG	
	R2.00	+/-0.010	2.0			RG	
	R0.063	+/-0.010	.063			RG	
	4.438	+/-0.010	4.448			VERN 08	
SIDE B	2.490	+0.005/-0.000	2.493			VERN 08	
	2.025	+0.005/-0.000	2.028				
	2.079	+0.005/-0.000	2.0835				
	2.145	+0.005/-0.000	2.150				
	2.209	+0.005/-0.000	2.2135				
	2.287	+0.005/-0.000	2.290				
	2.363	+0.005/-0.000	2.3665				
	0.200	+/-0.010	.200			VERN 08	
	R0.063	+/-0.010	.063			RG	
	R2.00	+/-0.010	2.0			RG	
	R0.063	+/-0.010	.063			RG	
	4.438	+/-0.010	4.446			VERN 08	
	99.76	+/-0.020	99.76			TAPE	

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WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	354	371	363	355	.017	0.045"
READING 2 L= 16.63	195	210	211	202	.016	
READING 3 L= 33.25	332	352	354	340	.022	
READING 4 L= 49.88	352	369	370	359	.018	
READING 5 L= 66.506	338	354	353	337	.016	
READING 6 L= 83.133	197	211	212	199	.015	
READING 7 L= 99.76	354	370	364	353	.017	

Calibration Result

Actual Block Thickness: 200-400

Sitiescan 250 Measured Thickness: 200-400

DAS
47

9-89

Measured by:	PMF	Audited by:	9-89	Preliminary Approval:	
Date:	2019-11-16	Date:	17-12-28	Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	
B	12.02.02	Dimension 4.438 was 4.500	KJ	
C	12.06.01	Wall thickness form added	KJ	